

NCR-19-7713



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3179-041
Job Sheet 202279



Part No: D3179-041

Job Qty: 16 pcs

Part Name: Litter Tie Down (Non-Locking)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/19

Job Tracking No:

Due Date: 11/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP A1 03.01.09 Added Acid etch end alodine RF IPP Rev:B Added Powder Coat 07-07-04 JLM
IPP REV:C AS PER REV D JLM 13-05-24 VERIFIED BY:DD IPP Rev:C 08-12-10 add part list DD verified
by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	16 pcs	11/18/19	11/18/19	0.00	1.32	Bandsaw - 1		DSP 19-11-04
110	HAAS 4 Axis - B4B	16 pcs	11/18/19	11/18/19	0.37	29.09	HAAS - 1 - B4B		DAS 19/11/5
							HAAS - 2 - B4B		52
							HAAS - 3 - B4B		9-89
							HAAS - 4 - B4B		
120	QC 2	16 pcs	11/18/19	11/18/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
									DAS 19/11/5
									9-89



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S229184



Part: D3179-041

Job No: 202279

Serial No/Batch: S229184

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/04/19

P.T.O.

130	QC 8	16 pcs	11/18/19	0.00	0.00	QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
140	Handfinish - 1-1 Chemical-B4B	16 pcs	11/18/19	0.00	1.30	Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	

VH 19/11/17

DAS
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BEB19-11-08

						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
150	QC 7	16 pcs	11/18/19	0.00	0.00	QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	
						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	
						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
						QC 7 - 61	
						QC 7 - 81	
						QC 7 - 76	
						QC 7 - 79	
160	Powdercoat - 1 White GI(A)- B4B	16 pcs	11/18/19	0.00	0.95	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
170	QC 3	16 pcs	11/18/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	

BK 19-11-8

M211886

START: 12:45 @ 1:300° FINISH: 1:15

BK 19-11-8

						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
180	Small Fab - 2 - B4B	16 pcs	11/18/19	0.00	2.38	Small Fab - 1 - B4B	
						Small Fab - 2 - B4B	
						Small Fab - 3 - B4B	
						Small Fab - 4 - B4B	
						Small Fab - 5 - B4B	
						Small Fab - 6 - B4B	
						Small Fab - 7 - B4B	
						Small Fab - 8 - B4B	
190	QC 5	16 pcs	11/18/19	0.00	0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
200	Packaging 3-1 - Stock - B4B	16 pcs	11/18/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	

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NOV 15 2019

NOV 15 2019

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ST225

					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					QC 21 - SA - 21 ✓	ST225
					QC 21 - SA - 70	
					QC 21 - SA - 53	
210 QC 21 - SA	16 pcs	11/18/19	0.00	0.00		

Part Op 100 - (Bandsaw) Cut blanks: 12.150" long

Descriptions: 110 - (HAAS CNC Vertical Machine) 1- Mill as per Folio FA297 Rev: AA & Dwg D3179-1 Rev: E

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC7-Inspect Chemical Conversion Coat)

160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____

170 - (QC3- Inspect Part Finish)

180 - (Small Fab) Assemble as per Dwg D3179

190 - (QC5- Inspect part completeness to step on W/O)

200 - (Identify as per dwg & Stock Location: _____)

210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6201	T Extrusion	16,2000 ft (1.0125 ea)	100-Bandsaw - 1	
D2372	Quick Release	32 pcs (2 ea)	180-Small Fab - 2 - B4B	
D2444	Pip Pin Assembly	16 pcs (1 ea)	180-Small Fab - 2 - B4B	
MS21042L3	Nut	16 Ea (1 ea)	180-Small Fab - 2 - B4B	
MS27039-1-13	Screw	16 Ea (1 ea)	180-Small Fab - 2 - B4B	
NAS1149D0332J	Washer	48 Ea (3 ea)	180-Small Fab - 2 - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	D6201	16	17	0
180-Small Fab - 2 - B4B	D2372	32	16	0
	D2444	16	3	0
	MS21042L3	16	2,767	0
	MS27039-1-13	16	286	0
	NAS1149D0332J	48	1,498	0

Part Specifications

Specifications could not be found.

Plex 10/23/19 1:35 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 202279
Description: Fwd Litter Tie Down Bracket		Part Number: D3179-1
Inspection Dwg: D3179	Rev: E	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.08	✓		U2V	SC-04
R0.40	+/-0.030	R0.40	✓		R.G.	REF
R0.38	+/-0.030	R0.38	✓		R.G.	
1.70	+/-0.030	1.70	✓		H.G.	31006
Ø0.191	+0.005/-0.001	Ø0.191	✓		G.P.	REF
10.500	+/-0.010	10.500	✓		H.G.	REF
4.250	+/-0.010	4.250	✓		U2V	SC-04
Ø0.246	+0.005/-0.001	Ø0.245	✓		G.P.	REF
1.50	+/-0.030	1.50	✓		U2V	
0.750	+/-0.010	0.750	✓		U2V	
1.000	+/-0.010	0.998	✓		U2V	
4.00	+/-0.030	4.00	✓		U2V	SC-04
1.00	+/-0.030	1.002	✓		H.G.	REF
1.38	+/-0.030	1.38	✓		U2V	SC-04
1.875	+/-0.010	1.879	✓		H.G.	
2.125	+/-0.010	2.128	✓		H.G.	REF
2.88	+/-0.030	2.865	✓		U2V	
3.31	+/-0.030	3.307	✓		U2V	SC-04
R0.375	+/-0.010	R0.375	✓		R.G.	
R0.50	+/-0.030	R0.50	✓		R.G.	
Ø0.191	+0.005/-0.001	Ø0.191	✓		G.P.	
R0.25	+/-0.030	R0.25	✓		R.G.	REF
R0.375	+/-0.010	R0.375	✓		R.G.	
R0.38	+/-0.030	R0.38	✓		R.G.	
12.00	+/-0.030	12.00	✓		H.G.	31006
9.000	+/-0.010	8.999	✓		H.G.	
7.50	+/-0.030	7.50	✓		U2V	SC-04
4.50	+/-0.030	4.50	✓		U2V	
2.88	+/-0.030	2.875	✓		U2V	
2.250	+/-0.010	2.249	✓		H.G.	31006
1.000	+/-0.010	0.998	✓		U2V	SC-04
0.50	+/-0.030	0.498	✓		U2V	

Measured by: DAS 52	Checked by: DAS 23	QC Inspector:
Date: 9-89 19/11/05	Date: 9-89 19/11/07	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	09.04.05	New Issue P/O D3179-041	KJ/DD	
B	12.10.04	Dimension 0.750 was 1.750	KJ	
C	13.05.27	Dimensions revised per Dwg Rev D	KJ	
D	16.06.08	Dimensions revised per Dwg Rev E	KJ	
E	17.02.16	Dimensions rearranged	KJ	

Entered: RLDate: Nov 18/19

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7713Route update only ☐

Job: <u>202279</u>		DISPOSITION		DEPARTMENT/PROCESS				Route update only ☐	
Part No. <u>3179-041</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☒ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date: <u>19/11/06</u>	Sequence #: <u>B 110</u>	QTY Affected: <u>1</u>		MARB (QSI042) DAS 9 9-89 <u>19-11-15</u>					
Description Work Order Deviation		Disposition				Completed By <u>S.C. 19/11/06</u>			
Part was inserted backwards on 3rd op.		Scrap and destroy				Lead hand / Supervisor <u>and</u> <u>19/11/06</u>			
QC / QA Coordinator DAS 9 9-89 <u>19-11-15</u>									
Root Cause		FAULT CATEGORY							
☒ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function				☒ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details:				☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up			